

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014946**Date Inspected:** 09-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay#2

Traveler rail: - Caltrans QA Inspector performed QA final dry MT testing on the CJP and fillet welds of OBG travel rails. The traveler and welds ID are 10TR1-023, 10TR2-009, 10TR-026, 11TR2-016, 11TR-026, 11TR-010 and 11TR1-003. All the CPJ and fillet welds have been accepted by ZPMC and ABF prior Caltrans QA inspection. Based on Caltrans QA MT test, the welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay #8

Cross beam: - Caltrans QA inspector observed a ZPMC welder performed FCAW CJP process on the flange to flange for floor beam of cross beam # CB17. The flanges welding areas have been pre-heating prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Bay#13

Caltrans QA Inspector observed three welders performed FCAW CJP weld process on three pieces interior stiffeners that connected to web plates of OBG 13A grillage mock up. The minimum preheat and maximum interpass temperature requirements for FCAW CJP weld are 160C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay #14

Caltrans QA Inspector observed two welders performed FCAW fillet weld process on stiffeners that connected to

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steel plate PL3383E of side plate #SP3091E. The minimum preheat and maximum interpass temperature requirements for FCAW CJP weld are 110C degree and 230 C degree. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. Caltrans QA inspector observed a fit up groups performed fit up and SMAW tack weld process on T-joint fillet weld. The T-joint is attached to stiffeners and 22mm wall thick plate # PL3245A and PL33389A of 13AE section of side plates. The side plate number is SP3065A and SP3091A. A numerous temporary tack welds have been welded attach between side plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay #16

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 60mm wall thick base plate of 13AW section of west line. The weld number and plate number are BP3075-001-002/PL3362D and PL3363D (side B). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on 100mm wall thick CJP weld. The CJP weld is attached to two base plates of 13AW section of west line. The weld number and plate number are BP3074-001-005/PL3362C and PL3361C. The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

CLOSING STATEMENT

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
